

P804228/WO/1

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5 Method and device for producing a peripherally
 closed hollow profile

10 The invention relates to a method of producing a
 peripherally closed hollow profile according to the
 preamble of patent claim 1 and to a device for this
 according to the preamble of patent claim 3.

15 A method of the generic type or a device of the generic
 type has been disclosed by DE 195 30 056 A1. In the
 method described there, a branch is shaped from a hollow
 profile blank by means of internal high pressure, this
 branch being supported at its cap by a yielding
 counterholder during the shaping process. In the marginal
 region of the cap, the branch in each case has a large
 radius, so that it bears only with its center region
20 against the end face of the counterholder. The supporting
 surface formed by the end face of the counterholder is
 enclosed by a collar-like, concave cutting edge. The
 center region of the cap of the branch is thus located,
 as it were, in a hollow of the counterholder. After the
25 desired height of the branch is reached, the forming
 pressure is considerably increased, as a result of which
 the radius in the marginal region of the cap of the
 branch decreases and the latter is pressed against the
 vertically projecting cutting edge. As a result, the
30 cutting edge cuts an encircling groove in the cap. The
 counterholder is now displaced toward the branch against
 the shaping direction of the branch, as a result of which
 the cutting edge of the counterholder cuts completely
 through the cap. In the process, the counterholder
35 plunges into the opening, thus produced, of the branch.
 In this case, a calibrating bead axially adjoining the

cutting edge smooths the inner wall of the branch. Considerable outlay is required in order to produce this cutting edge of special design. Furthermore, this cutting edge of special design is subjected to extremely pronounced loading by the increased internal pressure above the forming pressure, a factor which relatively quickly leads during operation to chipping at the cutting edge and thus results in a short service life of the counterholder. On account of the described high susceptibility of the cutting edge to the high, fluidic and mechanical loads, severing of the cap in series production in a reliable manner in terms of the process is not possible, since, after damage to the cutting edge, the stamping of the openings at the branch is effected only incompletely and as a result the component thus produced has to be scrapped. The costs arising here are considerable, which, in addition to the increased use of material, also include the downtimes for re-setting or repairing the counterholder.

The object of the invention is to develop a method of the generic type to the effect that the production of a hollow profile having secondary features and/or branches is made possible, during which reliable severing of the cap of the secondary feature or of the branch is achieved in a simple manner. Furthermore, a device for carrying out the method is to be shown.

The object is achieved according to the invention by the features of patent claim 1 with regard to the method and by the features of patent claim 3 with regard to the device.

The invention is based on the surprising knowledge that the cap of the secondary feature and/or of the branch can be neatly severed even at an internal high pressure which

corresponds at most to the forming pressure for forming the hollow profile from the blank. Unlike in the prior art, the severing of the caps is effected solely by a stroke of the counterholding punch in the opposite
5 direction to the expansion direction of the hollow profile. In the process, the end face of the counterholding punch runs in a continuously even manner and thus has no cutting or severing contours of special design. As a result, not only is the counterholding punch
10 of markedly simpler configuration, which considerably reduces the outlay in terms of equipment, but the end face and the severing contour of the counterholding punch also become less susceptible to mechanical loads, which ensures especially long durability of the severing
15 contour of the counterholding punch. There is also the fact that the internal high pressure still does not have to exceed the forming pressure in order to sever the cap of the secondary feature and/or of the branch, but rather the forming pressure normally applied or also pressures
20 which do not exceed said forming pressure are sufficient in order to neatly sever the cap, a factor which additionally relieves the severing contour. Excessive outlay in terms of equipment is not necessary for this purpose, this outlay being necessary at pressures which
25 exceed the forming pressure, since the closure force for the hydroforming tool can only be applied by extraordinarily powerful hydraulic cylinders and an extremely robust press frame. However, the width of the annular gap between the wall of the passage, which is
30 formed in the forming tool and in which the punch is guided in a displaceable manner, and the punch circumference should correspond approximately to the wall thickness of the secondary feature or of the branch, since otherwise hollow profile material can be displaced
35 into the annular gap by means of the internal high pressure during the shaping of the branch or of the

secondary feature, a factor which may lead to an undesirable shape of the branch or of the secondary feature and also to premature severing of the cap on account of the hollow profile material bearing against the severing contour. Therefore reliable severing of the cap of the secondary feature or of the branch is achieved overall in a simple manner by the solution according to the invention.

10 In an especially preferred development of the invention as claimed in claim 2 or in a corresponding preferred development of the device according to the invention as claimed in claim 5, the secondary feature and/or the branch, after the severing operation, by a plunging
15 movement of the counterholding punch into the opened secondary feature and/or the branch, is calibrated by means of a calibrating contour corresponding to the shape of the secondary feature or of the branch. Said calibrating contour adjoins the punch end on the side
20 facing away from the hollow profile. A number of practical tests have shown that the known encircling bead is not necessary in order to calibrate the secondary feature or the branch. On the contrary, it may be dispensed with in a simple manner, which substantially
25 simplifies the configuration of the counterholding punch. The configuration of the counterholding punch is merely to be adapted to the desired shape of the branch or of the secondary feature.

30 In a further, especially preferred development of the device according to the invention as claimed in claim 6, an encircling collar is formed on the counterholding punch and directly adjoins the calibrating contour on the side facing away from the hollow profile. This ensures
35 that the inhomogeneous material distribution of the secondary feature or of the branch which occasionally

occurs due to the calibration and which leads to an unevenly drawn-in margin of the branch or of the secondary feature is made more uniform by the collar being pressed axially onto the end edge, obtained by the
5 trimming, of the secondary feature or of the branch. The end edge, which is of high quality on account of its evenness and as a result of the almost tolerance-free design, has a favorable effect for subsequent processes for connecting the hollow profile to further components
10 which have to be fastened to the branch or the secondary feature in the sense that the joining gap between the end edge and the component is of uniform size and therefore a homogeneous joint which thus provides an especially good long-term hold is achieved. In this case, joining
15 techniques such as welding, adhesive bonding or the like can be used in a reliable manner.

In a further, especially preferred configuration of the device according to the invention as claimed in claim 4,
20 the punch end which contains the severing contour is of frustoconical design and has bevel surfaces facing the secondary feature or the branch. Due to the conical shape of the counterholding punch, a radially encircling sealing seat is produced on the branch or secondary
25 feature, as a result of which a pressure drop inside the hollow profile is prevented in a most advantageous manner. Thus, by means of a plurality of stamping counterholding punches arranged at the hollow profile, a plurality of branches can be opened simultaneously or one
30 after the other, that is to say the cap can be severed from the branch, without the internal high pressure in the hollow profile dropping and thereby resulting in inadequate process reliability.

35 In a further preferred development of the device according to the invention as claimed in claim 7, the end

edge of the counterholding punch is rounded. The rounding of the end edge, which forms the severing contour, additionally prevents a severing operation from already being effected during the shaping of the branch or of the secondary feature. In this way, during the subsequent deliberate severing of the cap, the same is not stamped out sharply but rather is torn out by the counterholding punch, as a result of which an undefined opening margin is produced, which, however, is smoothed by the subsequent calibration and therefore leads to the desired production result.

The invention is explained in more detail below with reference to two exemplary embodiments shown in the drawings, in which:

fig. 1 shows a lateral longitudinal section of a device according to the invention in the expansion phase of the hollow profile, with yielding counterholding punch,

fig. 2 shows a lateral longitudinal section of the device from figure 1 after completion of the hollow profile expansion, with a counterholding punch severing the cap of the shaped secondary feature,

fig. 3 shows a cutaway side view of a counterholding punch of a device according to the invention, with a calibrating contour adjoining the punch end at the rear,

fig. 4 shows a cutaway side view of a counterholding punch of a device according to the invention, with an encircling collar.

Shown in figure 1 is a device 1 which comprises a

hydroforming tool 2 and with which a peripherally closed hollow profile 3, which is inserted into the hydroforming tool 2, serves with a secondary feature and/or a branch 4. Furthermore, the device 1 contains a counterholding punch 5 which is integrated in the forming tool 2 in such a way as to be displaceable with little clearance.

To form said hollow profile 3, a hollow profile blank 23 inside the hydroforming tool 2 is put under such a fluidic internal high pressure P_1 that said hollow profile blank 23 expands and comes into contact with the cavity 6 of the forming tool 2, in which the blank 23 is inserted, in such a way as to conform to the contour. In the region of a passage 7 which is formed in the forming tool 2 and in which the counterholding punch 5 is accommodated in a displaceable manner, the hollow profile material is displaced into said passage 7 as a result of the internal high pressure P_1 and forms a secondary feature or the branch 4 in the process. To shape the branch 4 in a reliable manner in terms of the process, it is supported by the end face 8 of the counterholding punch 5 while it is being produced, the punch 5 yielding in the arrow direction with increasing shaped length of the branch 4. In order to deliver sufficient hollow profile material into the expansion region of the branch 4, two axial punches 9 of the device 1 are provided, which act upon the hollow profile 3 on both ends in a sealing manner and advance both ends 10 in the arrow direction in the direction of the expansion region during the expansion.

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As shown in figure 2, after the desired branch length has been achieved, the drive of the counterholding punch 5 is reversed, so that the latter plunges into the secondary feature or the branch 4 and in the process severs its cap 11, with a hole slug being formed, by means of a severing contour which is formed by the end edge 12 of the punch

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5. This takes place according to the arrow direction with a force F. In the meantime, a pressure which corresponds to or is lower than the forming pressure prevails in the hollow profile 3. The end face 8 enclosed by the end edge 12 of the punch 5 runs in a continuously even manner. In order to permit problem-free plunging into the branch 4, the width of the annular gap 22 between the circumference 13 of the punch 5 and the passage wall 14 is dimensioned in such a way that it corresponds approximately to the wall thickness of the secondary feature or of the branch 4. The cap 11 of the branch 4 is therefore severed solely by a stroke of the counterholding punch 5 in the opposite direction to the expansion direction of the hollow profile 5. After the pressure is released, the hydroforming tool 2 is opened and the finish-formed and processed hollow profile 3 is removed.

As can be seen from figures 1 and 2, the counterholding punch 5 can be of continuously cylindrical design. In deviation therefrom, the punch end 15 which faces the branch 4 and contains the severing contour may be of frustoconical design according to fig. 3, in which case it has bevel surfaces 16 facing the secondary feature or the branch 4. The opened branch 4 is sealed off in a completely pressure-tight manner via these bevel surfaces 16. As a result, a pressure drop inside the hollow profile 3 is avoided, so that branches 4 formed at other points of the hollow profile 3 can be effected sequentially in a reliable manner in terms of the process by severing the cap by means of a counterholding punch 5 arranged there in each case.

In deviation from the preceding exemplary embodiment of the configuration of the counterholding punch 5, as can be seen from figure 3, a counterholding punch 17, according to figure 4, in another exemplary embodiment,

additionally has a calibrating contour 18, which, on that side of the punch 17 which faces away from the hollow profile, adjoins the punch end 19 and is designed in accordance with the contour of the secondary feature or
5 of the branch. In this way, when the counterholding punch 17 plunges deeper into the branch 4, the region of the opening on the branch, this region being formed by the cap trimming, is readily smoothed to a sufficient extent in accordance with the desired shape. This provides for
10 optimum connection to further components which have to be put into or onto the branch of the hollow profile 3. Furthermore, an encircling collar 20 of the counterholding punch 17 directly adjoins the calibrating contour 18 on the side facing away from the hollow
15 profile. This collar 20 acts upon the end face of the opening margin of the branch, thereby ensuring uniform evenness of this end face. If need be, the end edge 21 of the counterholding punch 17 may also be rounded in order completely to prevent an encircling predetermined
20 breaking point from being produced during the supporting function of the counterholding punch 17, which predetermined breaking point may burst open at least locally on account of the prevailing internal high pressure, whereupon the further formation of the branch 4
25 can no longer be effected in a reliable manner in terms of the process. Nonetheless, after the supporting function of the counterholding punch 17 has been dispensed with, the cap 11 can still be severed from the branch 4 by the rounded end edge 21 of the punch end 19.